

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013254**Date Inspected:** 15-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ye Yong Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

WEST TOWER LIFT 1

This QA Inspector observed ZPMC qualified welding personnel identified as 040704. Perform Flux Core Arc Welding (FCAW) on West Tower lift 1 skin B exterior bearing stiffener. Joint identified as WSD1-SA279-25, ZPMC QC Identified as Fu Wei Min, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 040609, 042218. Perform Flux Core Arc Welding (FCAW) on West Tower lift 1 skin E, exterior bearing stiffener. Joint identified as WSD1-SA225-F/H-49, 29, ZPMC QC Identified as Fu Wei Min, The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed during random Visual inspection, ZPMC Magnetic Particle Testing (MT) Inspector performed MT on bearing stiffener of West Tower lift 1 skin D outside, For more information see below attached photo.

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NORTH TOWER LIFT 1

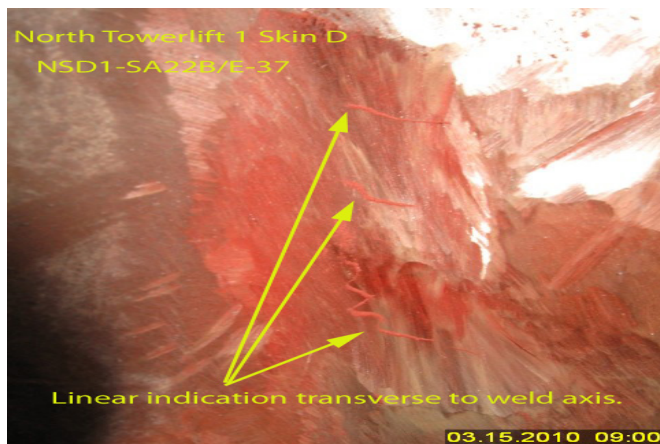
During random Visual Inspection This QA Inspector observed ZPMC MT Inspector performed MT on North tower lift 1 skin D Bearing plate. Joint identified as NSD1-SA22B/E-37. During MT found linear transverse indication to weld axis. For more information see below attached photo.

EAST TOWER LIFT 1

This QA Inspector observed ZPMC qualified welding personnel identified as 040713, 059521. Perform Flux Core Arc Welding (FCAW) on East Tower lift 1 skin C inside, exterior bearing plate. Joint identified as ESD1-SA294F/G-23, 5, ZPMC QC Identified as Xang Ming Ming. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

This QA Inspector observed ZPMC qualified welding personnel identified as 049141, 040723. Perform Flux Core Arc Welding (FCAW) on East Tower lift 1 skin E inside, exterior bearing plate. Joint identified as ESD1-SA227F/H-1, 15, ZPMC QC Identified as Xang Ming Ming. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2333-Tc-P4-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

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Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer